Date User: Job Number P.O. Number Prsht Rev. First Issue Previous Run Written By Checked & Approved By Comment

Friday, 10/5/2007 10:58:54 AM

Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services

: 35037 : 10584 **Estimate Number**

: 10/5/2007 This Issue

: NC : 30373

S.O. No. : NA

Type : SMALL /MED FAB

Re-format NG : Est: B 02.02.22 Est Rev:C Now on Waterjet 06-12-06 JLM **Part Number Drawing Number**

Drawing Name

: D1048 - D1048 REV A

: CLAMP

: N/A Project Number **Drawing Revision**

Material Due Date : 10/12/2007

Each

Additional Product

Job Number:



Seq. #:

Description: 304/316 .063 Sheet

M304S16GA 1.0

Comment: Qtv.:

0.0116 sf(s)/Unit

Total: 0.5775 sf(s) B 07-10-16 304/316 .063 Sheet

Batch: 105 130

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D1048 Dwg Rev:__

Prog Rev:

B 07-10-16



2-Deburr if necessary

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



\$67-10-16



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0

QC8

SECOND CHECK



Comment: SECOND CHECK



5.0 SMALL FAB 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Deburr if required. Break all sharp corners .010 / .020 as per dwg.



SAD

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
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QA: N/C Closed: ____ Date: ____

NCR:		W	ORK OR	DER NON-CONFORMANC	E (NCR)			
		Description of NC		Corrective Action Section B		Verification	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector
07-12-0	3	Scrap one part, today was unclear, fart was		Screp I destaroy	SAN			
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NOTE: Date & initial all entries

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Job Number: 35037 Part Number: D1048 Seq. #: Machine Or Operation: Description: 5.0 BRAKE NC NC BRAKE 1-Form as per dwg D2010 using DT8053 7.0 CC5 INSPECT WORK TO CURRENT STEP 8.0 POWDER COATING	User: * Kim	Jonnston	Process Sheet	<u> </u>
Job Number: 35037 Part Number: D1048 Seq. #: Machine Or Operation: Description: 6.0 BRAKE NC NC BRAKE 1-Form as per dwg D2010 using DT8053 7.0 CC5 INSPECT WORK TO CURRENT STEP Courts Comment: INSPECT WORK TO CURRENT STEP 8.0 POWDER COATING POWDER COATIN		CU-DAR001 Dart Helicopters Services	Drawing Name: CLAMI	;
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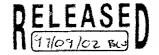
Dart Aerospace Ltd

W/O: WORK ORDER CHANGES								
DATE	STEP	PRO	CEDURE CHANGE		y Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Category:	NCR:	Yes No D	QA:	Date: _	
				G	A: N/C Clos	ed:	Date: _	

	•	WORK ORDE	R NON-CONFORMANC	E (NCR)			
	Description of NC		Corrective Action Section B		Varification		A
STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	Approval QC Inspecto
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NOTE: Date & initial all entries

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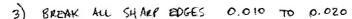


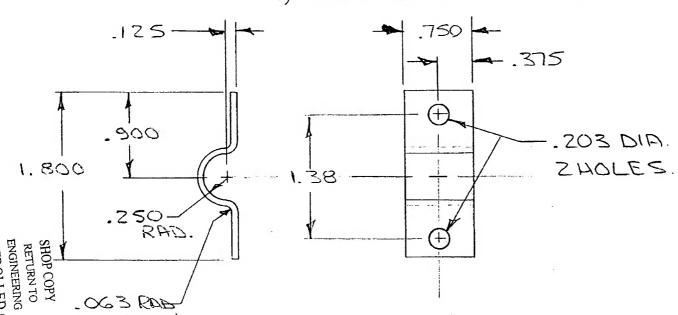
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STAINLESS STEEL T304#ZB .062 THICK

FINISH: POWDER COAT BLACK SANDTEX (REF. 4.3.5.7)

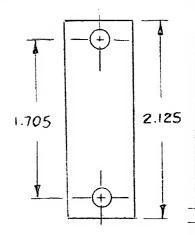
PER DART QSI 005 4.3





UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

-063 RDB



FLAT PATTERN



A	REVISION			RIVET CODE SHAL	L BE PER NAS 523	PARTNO.	ITEM	DES	CRIPTION	MATE	RIAL	SPEC_/YENDOR
RF	DRAWN .	THES DRAWING IS PRIVATE AND CONFIDENTIAL AND IS NOT TO BE USED FOR ANY PURPOSE OR COP WITHOUT THE PERMISSION OF DART AFRO	THE HOMEOUT SZERVE BY THE CHARLES SO CONTINUES AND COMMUNICATED TO ANY OTHER PERSON	BASIC COOK	M"HEAD MEAR SIDE	CONTRACT NO.	<u> </u>			DAR'	T AERO ACCE	SSORIES INC.
46	APPROVED			0-00001	F-HEAD FAR SIDE	DALIM		DATE	UAI	R VANCO	UVER	CANADA
3		REOLIREMENTS — UNLES	S OTHERWISE SPECIFIED	DIGITH NO OF SHEETS	LENGTH OASH NO.	BRADLE	1/4	457				
05 47. PATE	DESCRIPTION OF CHANGE	1. DINEDISIONS ARE REPORTES 2. SURFCE ROUGHIESS 19-4 3. REMOVE SHAMP EDGES, 0.15 MAX. 4. THERADS PER MR S - 7242 5. HOUSE WE AND 10387	1 TOLERANCES JX & 0.30 7. ANGLES 8 W 3. PARALLELISM 1.0075 4. ECCENTRICITY 005 MAX.		CODES	BR DOLF.	۲. [, 191	time	LLAM	(P	
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Description:	CLAMP				Part Number:	D1048
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	FIRST	ARTICLE IN		ON CHE		
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
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.375	4- ,010	,375	×			
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2.125	1/2 ,010	861,6	×			
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Date: 07-10-16 Date: 03/10/16 Date: 01-2	Measured by: 18	Audited by:	8	Prototype Approval:	
	Date: 07-10-11	Date:	03/10/16	Date:	-a/2-

Rev	Date	Change	Revised by	Annrowed
! A		New Issue	Hevised by	Approved
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